

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 34647		
Estimate Number	: 12040		
P.O. Number	: N/A	Part Number	: D33557
This Issue	: 9/12/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3355 REV:-B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26944	Drawing Revision	: B
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 9/21/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	8 Um: Each
Comment	: est rev A 06.01.19 new issue EC		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	M1018TR1000W095	1018-1025 Round Tubing
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M1018TR1000W095

1018-1025 Round Tubing

MOISTURE 1000 WZL or 1000 WZL

**Comment:** Qty.: 0.7224 f(s)/Unit Total : 5.7792 f(s)

1018-1025 Round Tubing

M 11591

Plot 07-09-12

20 BAND SAW

BAND SAW

Plot 09.12

Comment: Cut blank 8.250" long

3.0 QC5

INSPECT WORK TO CURRENT STEP

5 April

40 PACKAGING 1

## PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

## Identify and Stock

Location: *W523*

PK 07.09.12

50 QC21

FINAL INSPECTION/W/O RELEASE

**Comment:** FINAL INSPECTION/W/O RELEASE




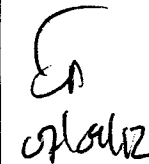
### Job Completion

u 07-02-14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

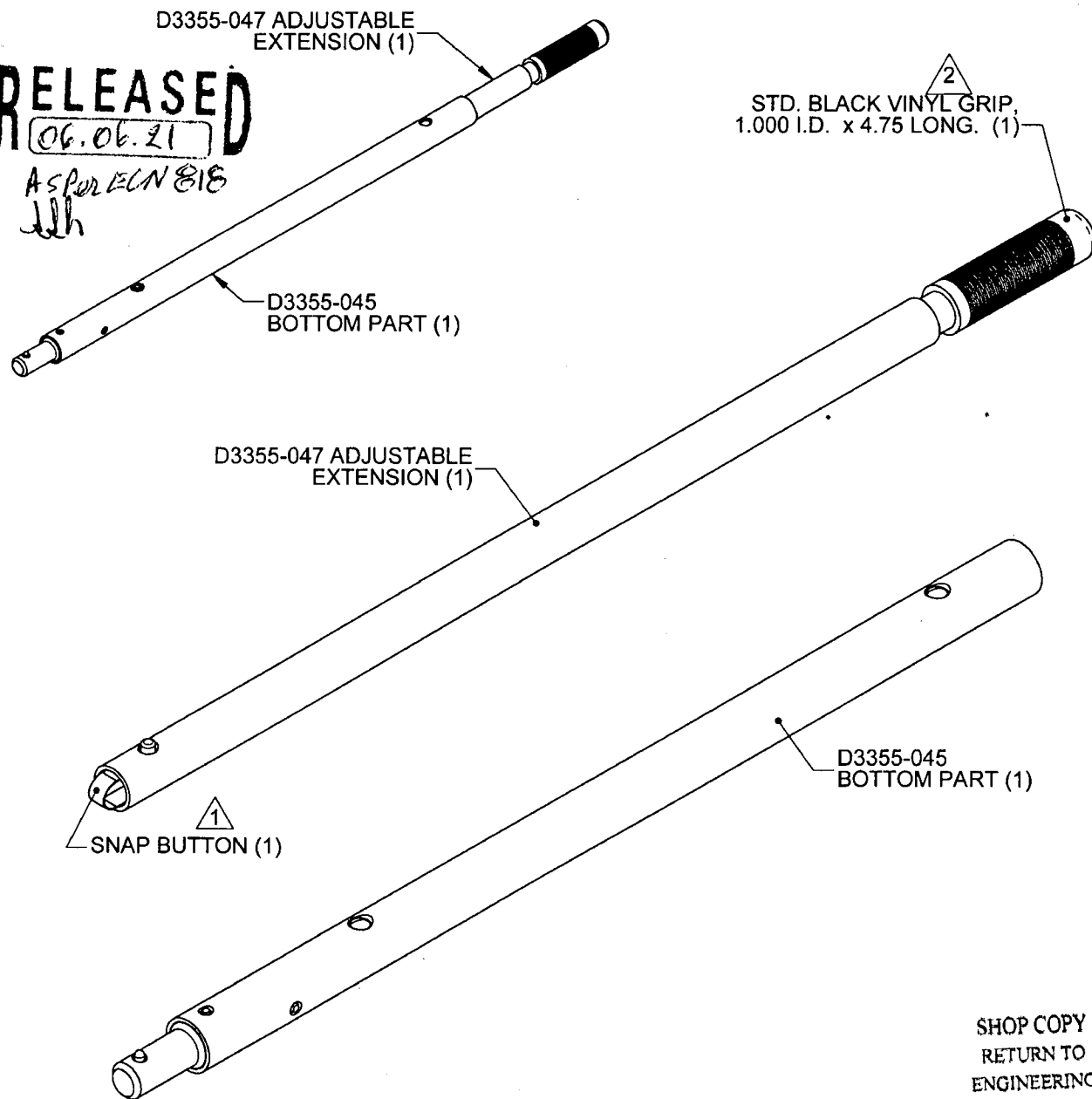
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ED Date: 07/09/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.12	1.0	M1018TR1000W09T NOT IN STOCK		M1018TR1000W120 IS ACCEPTABLE REPLACEMENT PDR @ SL 042.	B/C 07.09.12			

NOTE: Date & initial all entries

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3355</b>	REV. B SHEET 1 OF 6
DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

**RELEASED**  
**06.06.21**AS PER ECN 818  
*[Signature]***D3355-041 HANDLE ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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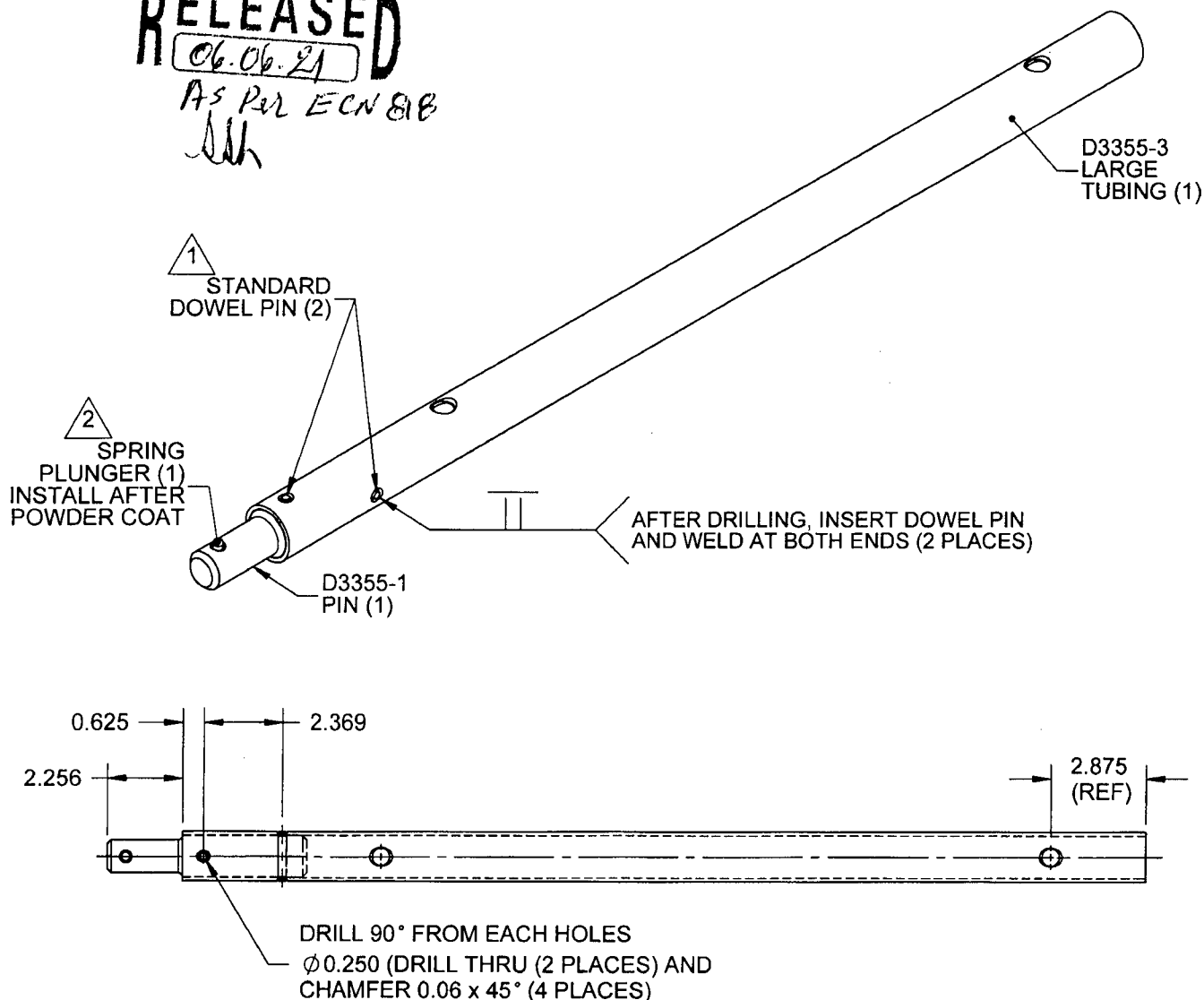
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

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**06.06.21**

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*[Signature]***D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN,  $\phi 0.250 \times 1.50$  LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO.
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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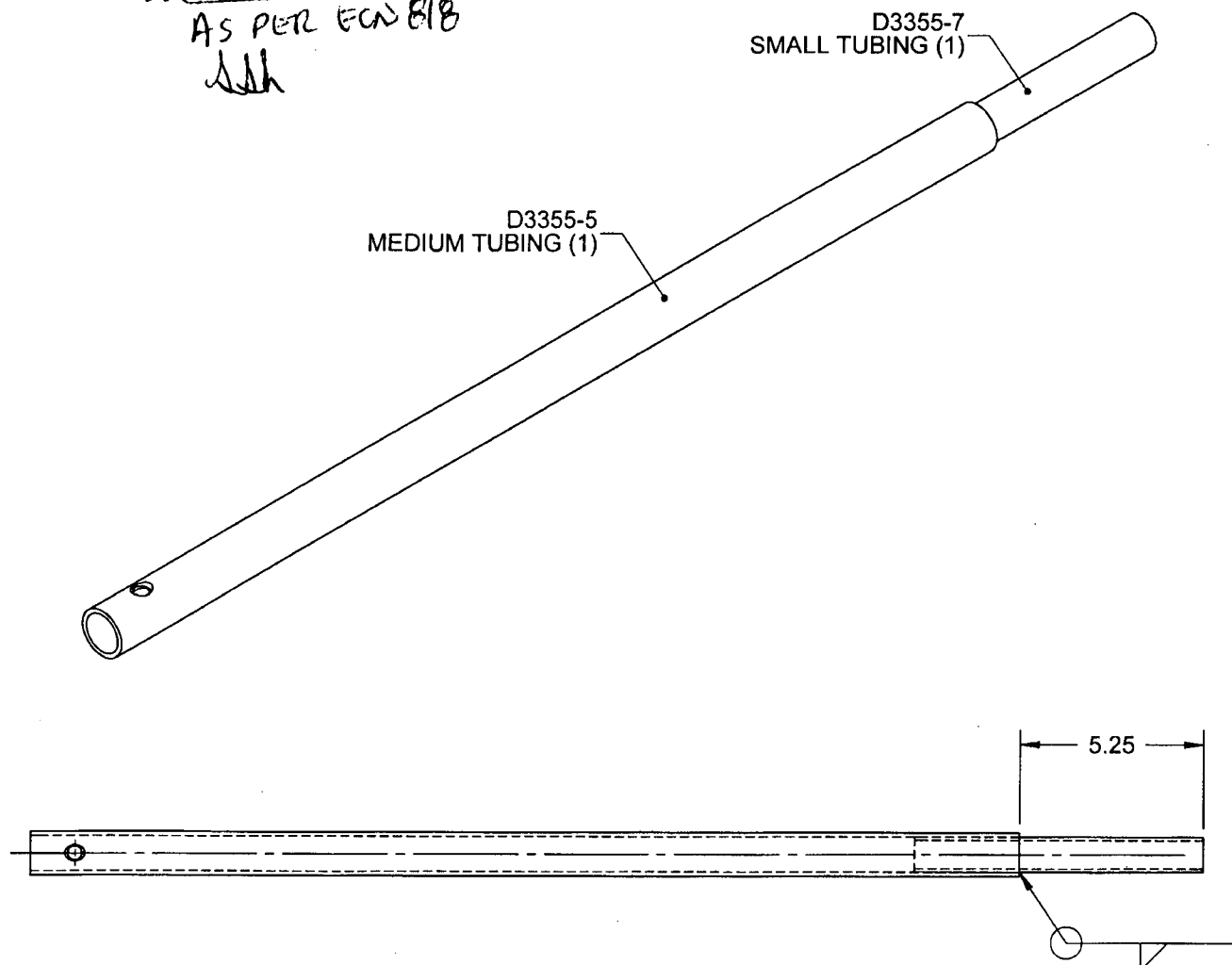




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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

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06.06.21

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[Signature]



**D3355-047 ADJUSTABLE EXTENSION**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

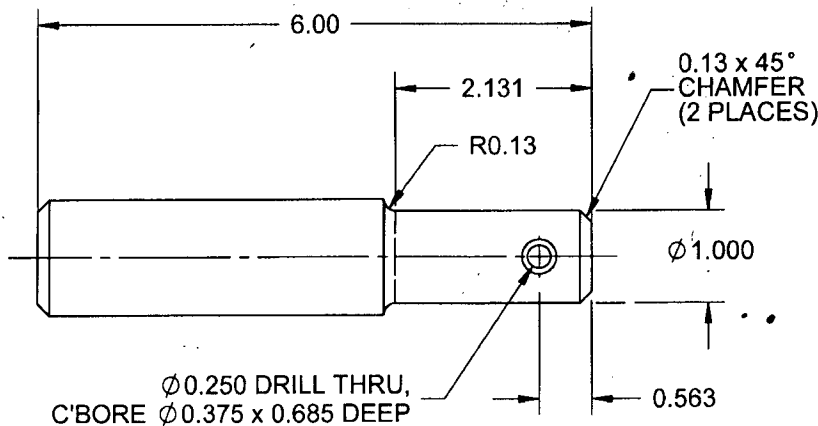
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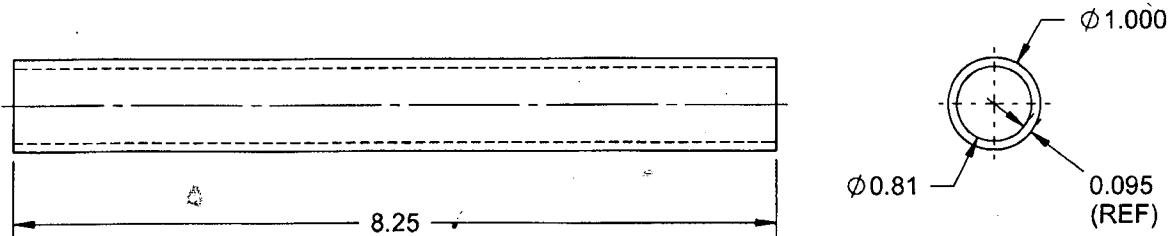
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:2

**RELEASED**  
*06.06.21*  
*AS PER ECN 818***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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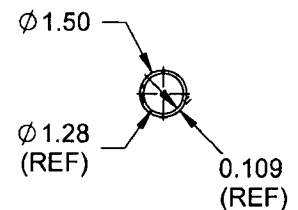
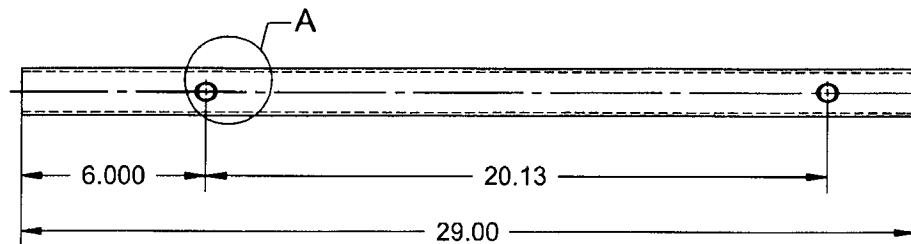
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:6

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
**SCALE 1 : 2**



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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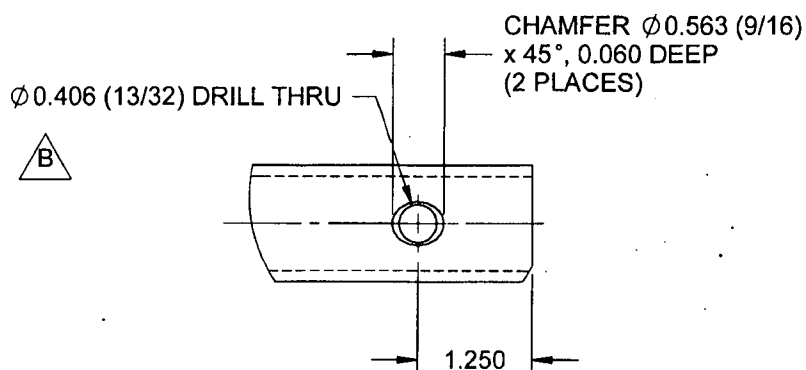
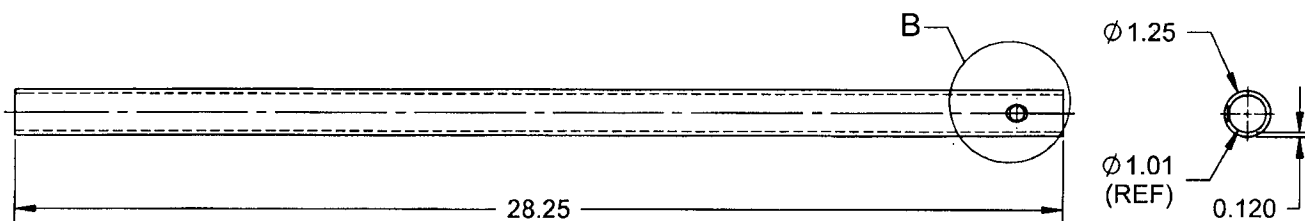
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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:5

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SCALE 1 : 2**D3355-5 MEDIUM TUBING****NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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